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D3791-1

Job Sheet 198544



Part No: D3791-1

Part Name: Wearpad

Job Qty: 12 pcs

DAS
21
9-09

Part Weight: 0 lbs

Job Created: 7/30/19

Due Date: 8/30/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG D3791 REV.B IPP Rev:A 08-05-13 new issue DD verified by:EC IPP Rev:B 08-05-22 revA as per dwg
ECN1191 DD verified by:EC IPP REV:C 18.11.09 AS PERR DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		8/30/19	0.17	0.98	Waterjet - Flow		DL19/09/04
110	QG 2	12 pcs		8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DL19/09/04
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	12 pcs	8/30/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - Brake NC - B4B	12 pcs	8/30/19	0.25 0.29	Small Fab - Brake - 1 - B4B	DAS 40 SEP 04 2019 9-89
				Small Fab - Brake - 2 - B4B	DAS 30 SEP 12 2019
				Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Automated Welding - B4B	12 pcs	8/30/19	0.00 4.10	Automated Welding - 1 - B4B	DAS 40 SEP 12 2019 9-89
160 QC 10	12 pcs	8/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	

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170 QC 5	12 pcs	8/30/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	EL
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Spray Paint - 2 - B4B	12 pcs	8/30/19	0.00 0.21	Spray Paint - 1 - B4B	• A219-9-13
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
190 QC 3	12 pcs	8/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	SEP 16 2019
				QC 3 - 19	DAS 40
				QC 3 - 43	9-88
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
200 Packaging 3-1 - Stock - B4B	12 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	FP-002
				Packaging 3 - 2 - B4B	20 19-9-12
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

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					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	12 pcs	8/30/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	100
					QC 21 - SA - 53	21

SEP 17 2019

Part Op 100 - 1-Cut as per Dwg D3791 Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg) 1-Deburr if necessary 2-Form on Brake as per Dwg D3791 using Jigs

140 - (QC5- Inspect part completeness to step on W/O) Ensure joggle as per dwg D3429

150 - ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M139018

160 - (QC10- Inspect visual per QSI004- ground welds)

170 - (QC5- Inspect part completeness to step on W/O)

180 - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI BATCH: S208066

190 - (QC3- Inspect Part Finish)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	3.5004 sf (.2917 ea)	100-Waterjet - Flow - 1	<u>5200442</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	4	366	0

Part Specifications

Specifications could not be found.

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FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype[illegible]

Measured by:	<i>dx</i>
Date:	19/09/04

Audited by:	
Date:	SEP 04 2019

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	
B	19.06.11	Drawing revision and dimensions updated	MG <i>[Signature]</i>	<i>[Signature]</i>

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only

DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Cross tube ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐		Skid-tube Machining ☐ ☐ ☐ Large Fab ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐		Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐					
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)							
Description Work Order Deviation				Disposition									
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				FAULT CATEGORY Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐						Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐		Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐	
Completed By				Lead hand / Supervisor									
QC / QA Coordinator				QC / QA Coordinator									